

Work Order ID 51902

Wednesday, September 09, 2009 11:04:42 A



Page 1

Item ID: D350-636-011

Accept



Setup Start



Revision ID: F

Item Name: Skidtube LH

Stop



Start Date: 9/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 9/25/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

BP mmt

Date: *09-9-09*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2750

Rev F

100

0.00



DOCUMENT CONTROL

DC

0.00

Memo

Document Control

Photocopy blue file and type labels per PPP D350-636-011 CHG 004

S 09/10/08

HJ for BG 09/10/08

B51902

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Item ID: D350-636-011

Accept

Revision ID: F

Item Name: Skidtube LH

Start Date: 9/10/2009 Start Qty: 1.00

Required Date: 9/25/2009 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

110

0.00



Skidtubes

Skidtubes

Skidtubes

Memo

0.00

1- Mark cut line on aft end of D2600-3-Bent using Jig DT 8150. Cut to length as per Dwg D2750. Deburr end

2-Drill pilot holes as per Dwg D2750 sheet 4 (D2750-1 details).Drill using drill Jig DT8150 & DT8863.

3- Mark fwd end for cutting using Drill Jig DT 8150 & DT8863 and cut as per dwg D2750.

4- drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500"

5- locate DT8330 off of blade fitting bolt holes and drill pilot holes for blade fitting

6-Open up holes for Detail B to 0.375" (4 holes per side)and blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750 .Open up holes for ground handling and detail C to 0.500" (8 holes per side)

7-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297".

8-Open up holes of Detail A to 0.297" (total of 2 holes per side)

9-Weld D2744 Cap as per Dwg D2750 and QSI 004.Fill grooves in bend left from bending as per QSI 004

A/R□□ Aluminum Rod

10-Grind welds flush as per Dwg D2750

8E 09/09/17

M/S 09 09 28 0

8E 09/09/17

D 9-9-28

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Item Name: Skidtube LH

Start Date: 9/10/2009 Start Qty: 1.00

Required Date: 9/25/2009 Req'd Qty: 1.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

12- Scribe batch# inside per dwg D2750

DP99-28

120

QC10- Inspect visual per QSI004- ground welds

0.00

27 8 02/02/28



QC

Memo

0.00

Quality Control

(70)

/

130

QC5- Inspect part completeness to step on W/O

0.00

27 8 02/07/28



QC

Memo

0.00

Quality Control

(70)

/

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

/

09

09

28

(1)

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Item ID: D350-636-011

Accept

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Item Name: Skidtube LH

Start Date: 9/10/2009 Start Qty: 1.00

Required Date: 9/25/2009 Req'd Qty: 1.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control



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Start Date: 9/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 9/25/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

160

0.00



Skidtubes

Skidtubes

Memo

0.00

1-Open up holes of Detail C and ground handling to 0.625" (total of 8 holes per side)
as per dwg D2750.

2-Open up holes of Detail B to 0.750" (total of 4 holes per side)
as per dwg D2750.

3- Open float hole to 0.500" (4 per side)

4-Chamfer holes of Detail B, C, ground handling and float holes per dwg D2750
(welding instructions on sheet 8)

5-Deburr and blow out all chips from inside of tube

6- Prepare tube for welding, remove alodine as required.

7-Bond web D2739 in place as per QSI 015

A/R ☐☐☐ Sikaflex-291

batch: ☐☐☐

exp. date: 10-2-20

8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004
(welding instructions on sheet 8)

A/R ☐☐☐ Aluminum Rod batch: M111999

9-Grind welds flush as per Dwg D2750 A.M. 09.10.05

10-Spot face ground handling holes section (total of 4 places per side) as per
dwg D2750

A.M. 09-10-05

9-9-28

AWM 9-9-28

(PD) →

09.10.01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D350-636-011 PAR #: _____ Fault Category: sketches NCR: Yes No DQA: / Date: 05-10-14
 Resolution: re-work Disposition: re-work QA: N/C Closed: / Date: 05-10-14

NCR: <u>51902</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
9/10/01	# 160.8	Pano Duran welding a pin hole inside of a 4-bolt spacer D3490-1. The 9th hole from aft. The pin hole is too deep inside to be fixed R.C. Process.		Grinding weld Flush and remove the 4th 4-bolt spacer from in the 9th hole from aft. and replace. D3490-1 B# B48277	PD 09.10.01	S 09/10/06		S 09/10/01
				A/R M111999	PD 09.10.01	S 09/10/06		S 09/10/07

NOTE: Date & initial all entries

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Cust Item ID:

Required Date: 9/25/2009 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

11-Deburr holes

170



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

Memo

0.00

2) Solid6



6

180



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

2) Solid6



6

190



HandFinish

Hand Finishing

Pressure Wash per QSI005 4.3

0.00

Memo

0.00

2) 09/10/09



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Cust Item ID:

Required Date: 9/25/2009 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum <i>M112260</i> Memo START TIME: <i>11:00</i> OVEN TEMPERATURE: <i>320°</i> FINISH TIME: <i>11:30</i>	0.00 0.00	<i>BK09-10-7</i>			<i>(1)</i>			
210 QC Quality Control	QC3- Inspect Part Finish Memo Inspect for foreign object per QSI 024	0.00 0.00	<i>99 09/10/07</i>			<i>(X1)</i>	<i>6</i>		
220 HandFinish Hand Finishing	HandFinishing Memo 1- Install inserts as per Dwg D2750	0.00 0.00	<i>M 09/10/09</i>			<i>(X1)</i>	<i>6</i>		

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Stop



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Start Date: 9/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 9/25/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

230

0.00



HandFinish

Hand Finishing

HandFinishing

Memo

✓ 1-Inspect for Foreign Objects

* 2-Spray inside of tube with "LPS-3" batch: N/A

✓ 3-Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D2750

SIKA FLEX 241

✓ BATCH: 112341

EXP DATE: 10/20

✓ 4-assemble o'ring to plug as per dwg D3492 and apply o'ring lube

A/R 55-o'ring lube batch: M101223

✓ 5-Coat all exposed fasteners with "LPS Procyon" batch: M104251

0.00

=> 41 09/10/02

X1

0

240

0.00



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

=> 5 o'clock



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Item ID: D350-636-011

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Setup Start



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Stop



Item Name: Skidtube LH

Start Date: 9/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 9/25/2009 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

280

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/10/13 *[Signature]*
09-10-5

Picklist Print

Wednesday, September 09, 2009 11:04:47 AM

Page 1
18

Work Order ID: 51902



Parent Item: D350-636-011RevF



Parent Item Name: Skidtube LH

Start Date: 9/10/2009

Required Date: 9/25/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2744RevC		Manufactured	No			110	Each	50.0000	1.0000			
Cap												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

50

44892

15

47488

35

D2600-3-BENTRevD1

Manufactured

No

110

Each

0.0000

1.0000



Extrusion Bent

D2743RevB

Manufactured

No

160

Each

294.0000

8.0000



Crossbolt Spacer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

LG

50

50281

50

Main Warehouse

ST

244

44891

2

45555

177

48275

65

[Signature]

[Signature]

BE 09/09/17

[Signature]

250675 (1) BE 09/09/16

AWM 9-9-29 (8)

Picklist Print

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Work Order ID: 51902



Parent Item: D350-636-011RevF



Parent Item Name: Skidtube LH

Start Date: 9/10/2009

Required Date: 9/25/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2739RevD 		Manufactured	No			160	Each	6.0000	1.0000			
350 I Beam												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
LG	4	
50353	4	
Main Warehouse		
ST	2	
47124	1	
47681	1	

B-52305 AWM 9-9-09

D3490-3RevA

Manufactured No

160

Each

112.0000

4.0000



Cross Bolt Spacer

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	112	
45560	22	
47471	35	
48276	55	

B-51930 AWM 9-9-09 (X4)

Picklist Print

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Work Order ID: 51902



Parent Item: D350-636-011RevF



Parent Item Name: Skidtube LH

Start Date: 9/10/2009

Required Date: 9/25/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3490-1RevA		Manufactured	No			160	Each	165.0000	4.0000			
Cross Bolt Spacer												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	165
45338	2
47118	4
47657	50
48277	109

ALS4-1032-225

Purchased

No

220

Each

8,753.000

38.0000



Insert

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	8753
107441	16
10768	8737

D3492-041RevC

Manufactured

No

230

Each

3.0000

8.0000



Plug Assembly

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	3
43816	3

AWM 9-9-29 (4) +/ see PTO

x38 09/10/07

x8 09/10/07 (21)

Picklist Print

Wednesday, September 09, 2009 11:04:47 AM

Work Order ID: 51902



Parent Item: D350-636-011RevF



Parent Item Name: Skidtube LH

Start Date: 9/10/2009

Required Date: 9/25/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3793-3RevA 		Manufactured	No			230	Each	22.0000	1.0000			
Wearshoe												

Warehouse
Location
Main Warehouse
ST

Loc Qty

Loc Code

22

47720

11

50216

11

X1 48 09/10/07

AN8C35A



Purchased

No

230

Each

167.0000

1.0000



BOLT

Warehouse
Location
Main Warehouse
ST

Loc Qty

Loc Code

167

102180

1

106896

1

110105

65

110847

100

X1 48 09/10/07

Picklist Print

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Work Order ID: 51902



Parent Item: D350-636-011RevF



Parent Item Name: Skidtube LH

Start Date: 9/10/2009

Required Date: 9/25/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3793-1RevA		Manufactured	No			230	Each	18.0000	1.0000			
Wearshoe												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

40551

47537

50231

18

1

4

13

230

Each

29.0000

1.0000

~~B50269~~ B50269

X1

ul 09/10/07

D3488-041RevB

Manufactured

No



Blade Fitting Assembly, LH

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

41853

44530

47348

29

1

8

20

X1

ul 09/10/07

Picklist Print

Wednesday, September 09, 2009 11:04:47 AM

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Parent Item Name: Skidtube LH

Start Date: 9/10/2009

Required Date: 9/25/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3794-3RevA		Manufactured	No			230	Each	27.0000	1.0000			



Gasket

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

27

46531

2

47440

2

47722

11

50248

12

AN6C44A

Purchased

No

230

Each

172.0000

4.0000



BOLT

Warehouse Loc Qty Loc Code

Location

OFFSHORE

1112720

FG

2

103964

2

Main Warehouse

ST

170

110105

4

110155

14

110665

1

110865

51

111605

50

111649

50

X

9/10/09

Picklist Print

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Work Order ID: 51902



Parent Item: D350-636-011RevF



Parent Item Name: Skidtube LH

Start Date: 9/10/2009

Required Date: 9/25/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21083C8 		Purchased	No			230	Each	90.0000	1.0000			
NUT												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

90

110584

5

111424

2

11637

21

112243

42

112492

20

x1 09/10/07

D3536-25RevA

Manufactured

No

230

Each

21.0000

1.0000



Gasket

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

21

45569

1

47011

2

47526

8

60266

10

x1 09/10/07

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Shop Packet Print

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Picklist Print

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Start Date: 9/10/2009

Required Date: 9/25/2009

Comments:

Start Qty: 1.00

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3631-1RevA 		Manufactured	No			230	Each	105.0000	8.0000			
Washer												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

B51908

x8 28 09/10/07

ST

105

38139

6

45353

16

47437

83

D3791-1RevA

Manufactured No

230

Each

18.0000

1.0000

Wearplate

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

18

47536

8

50269

10

x1 28 09/10/07

Picklist Print

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Parent Item: D350-636-011RevF



Parent Item Name: Skidtube LH


Start Date: 9/10/2009

Required Date: 9/25/2009

Comments:

Start Qty: 1.00

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960C10L  washer		Purchased	No			230	Each	7,340.000	38.0000			

Warehouse
Location

Loc Qty

Loc Code

OFFSHORE

FG

100

103585

100

Main Warehouse

FP

-44

112116

-44

Main Warehouse

ST

7284

112116

2284

112612

5000

x38 9/9/09/07

Picklist Print

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Parent Item Name: Skidtube LH

Start Date: 9/10/2009

Required Date: 9/25/2009

Comments:

Start Qty: 1.00

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2745RevB		Manufactured	No			230	Each	272.0000	8.0000			
Bushing												

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 272

34817 2

36230 8

37303 1

39587 2

40726 2

41114 2

42778 19

43754 2

44893 37

45556 69

46695 18

48278 110

AN3C5A

Purchased

No

230

Each

642.0000

34.0000



Bolt

x8 28 09/10/07

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 642

111424 8

111707 334

112314 200

112489 100

11 112720

x34 34 09/10/07

Picklist Print

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Comments:

Start Qty: 1.00

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3537-1RevC		Manufactured	No			230	Each	45.0000	3.0000			

Wearpad

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
FP	45	
48288	2	
50321	43	

B31918

x3 98 09/10/07

AN960C816L

Purchased

No

230

Each

330.0000

1.0000



WASHER

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	330	
104093	2	
107520	4	
110139	29	
110372	36	
110584	100	
111424	159	

x1 98 09/10/07

D3492-043RevC

Manufactured

No

230

Each

0.0000

8.0000



Plug Assembly

B31642

x5 98 09/10/07

Picklist Print

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Wednesday, September 09, 2009 11:04:48 AM

Work Order ID: 51902



Parent Item: D350-636-011RevF



Parent Item Name: Skidtube LH

Start Date: 9/10/2009

Required Date: 9/25/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN3C6A 		Purchased	No			230	Each	1,048.000	4.0000			
BOLT												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

1048

(110372)

72

111982

976

x4 21 09/10/09

NAS1611-013 *

Purchased

No



230

Each

320.0000

1.0000



O-RING

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

320

106513

11

111424

109

111758

200

x8 21 09/10/09

NAS1611-010 * ?

Purchased

No



230

Each

345.0000

1.0000



O-RING

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

345

110715

50

110915

295

025 94-3 / 135613 x8 21 09/10/09

PT037

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W/O: 51902

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
09/10/07	N/A	Replace NAS1611-010 "O" Rings for D2594-3 / B51613 "O" Rings	JL	09/10/07	⑤		S 09/10/07

Part No: D350-636-011 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Wednesday, September 09, 2009 11:04:48 AM

Work Order ID: 51902

Parent Item: D350-636-011RevF

Parent Item Name: Skidtube LH

Comments:

Start Date: 9/10/2009

Required Date: 9/25/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3535-25RevB		Manufactured	No			230	Each	11.0000	1.0000			

Wearshoe

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse	B 51663	
ST	11	
47523	11	

xl 41 09/10/09

D3794-1RevA

Manufactured No

230

Each

33.0000

1.0000



Gasket

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	33	
46530	1	
47212	2	
47721	4	
51668	26	

xl 25 09/10/09

Picklist Print

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Work Order ID: 51902



Parent Item: D350-636-011RevF



Parent Item Name: Skidtube LH


Start Date: 9/10/2009

Required Date: 9/25/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21043-6  NUT		Purchased	No			230	Each	1,132.000	4.0000			

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	1132	
110584	34	
111424	98	
112314	1000	

24 09/10/09

D3493-1RevA



Manufactured No

Washer

260 Each 115.0000 2.0000



<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	115	
44902	15	
47710	100	

47710 9/10/8 @ SB

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Picklist Print

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Work Order ID: 51902

Parent Item: D350-636-011RevF

Parent Item Name: Skidtube LH


Comments:

Start Date: 9/10/2009

Required Date: 9/25/2009

Start Qty: 1.00

Required Qty: 1.00


Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21083C8  NUT		Purchased	No			260	Each	90.0000	2.0000			

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST	90	
110584	5	
111424	2	
111637	21	
112243	42	
112492	20	

112243 *sel*

AN8C21A  BOLT		Purchased	No			260	Each	110.0000	2.0000			
---	--	-----------	----	--	--	-----	------	----------	--------	--	--	--

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST	110	
105160	1	
107596	1	
107924	2	
109092	2	
110341	2	
110342	2	
111605	50	
111684	50	

111684 9/10/8 @ *sel*

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Work Order ID: 51902



Parent Item: D350-636-011RevF



Parent Item Name: Skidtube LH

Start Date: 9/10/2009

Required Date: 9/25/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960C816L S		Purchased	No			260	Each	330.0000	2.0000			
WASHER												

B-52305

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse		
ST	330	
104093	2	
107520	4	
110139	29	
110372	36	
110584	100	
111424	159	

B-52305 Ann 9-9-2008

NAS1515H3L



WASHER

Purchased

No

260

Each

350.0000

4.0000



Warehouse	Loc Qty	Loc Code
<u>Location</u>		
OFFSHORE		
FG	40	
102472	40	
Main Warehouse		
ST	310	
110450	2	
110806	8	
111819	300	

111424 SP

(x4) 09/10/07

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Picklist Print

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Work Order ID: 51902



Parent Item: D350-636-011RevF



Parent Item Name: Skidtube LH


Start Date: 9/10/2009

Required Date: 9/25/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2741RevC  Blade, 350 Skidtube		Manufactured	No			260	Each	40.0000	1.0000			

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	40	
20770	0	
45320	1	
47113	39	

47113 sf

D3532-1RevA

Manufactured No

260

Each

43.0000

2.0000



Spacer

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	43	
38161	2	
44904	41	

44904 9/10/08 sf

Picklist Print

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Work Order ID: 51902



Parent Item: D350-636-011RevF



Parent Item Name: Skidtube LH

Start Date: 9/10/2009

Required Date: 9/25/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
NAS1515H8L		Purchased	No			260	Each	127.0000	2.0000			



WASHER

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	127	
107581	34	
108964	1	
111650	92	

111650 9/10/8 P22

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

GENERAL NOTES:

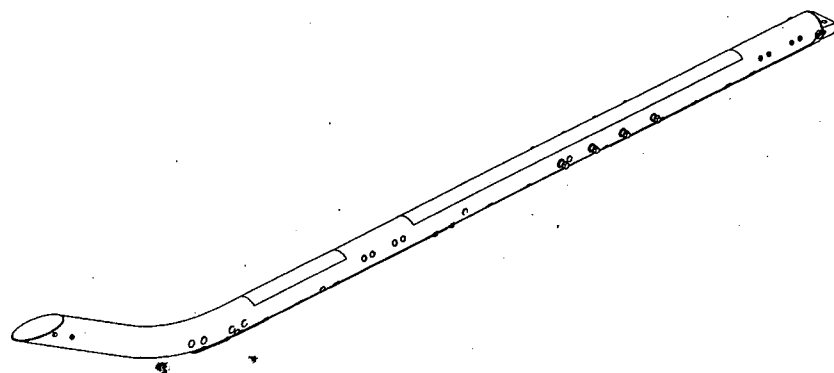
- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH:
ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ($\phi 0.297$) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
POWDER COATING WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

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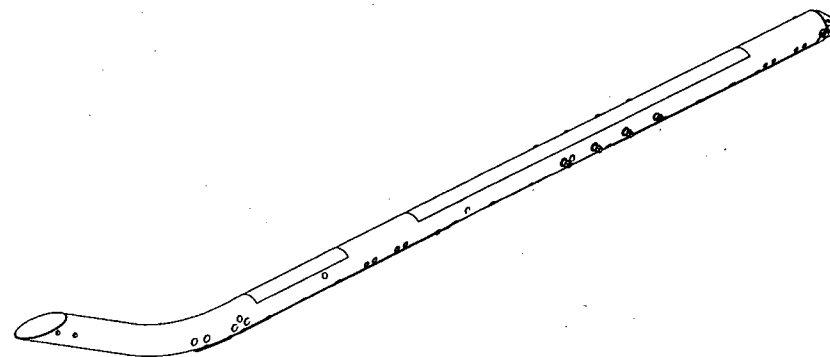
RELEASED
68 107-22 107

F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/3 REPLACES D3535-13/35 (ZN C8-1); D3794-1/3 REPLACES D3536-13/35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS; CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741, QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	RA	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	RA		
CHECKED	RA	DRAWING NO.	REV. F
MFG. APPR.	RA	D2750	SHEET 1 OF 11
APPROVED	RA	TITLE	SCALE
DE APPR.	RA	350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	COPYRIGHT © 1988 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

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D2750-041 350 SKIDTUBE ASSEMBLY, LH

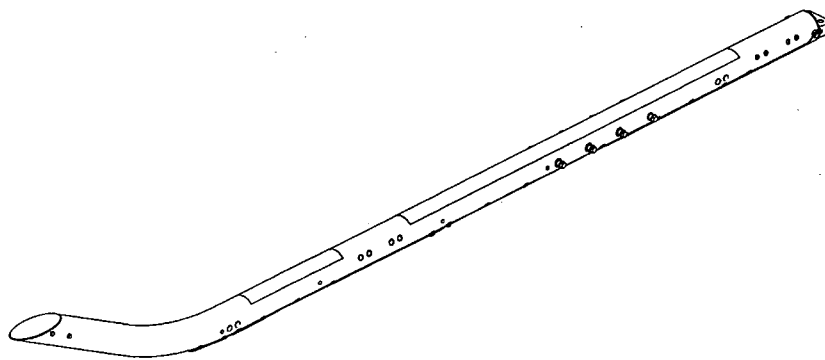


D2750-042 350 SKIDTUBE ASSEMBLY, RH

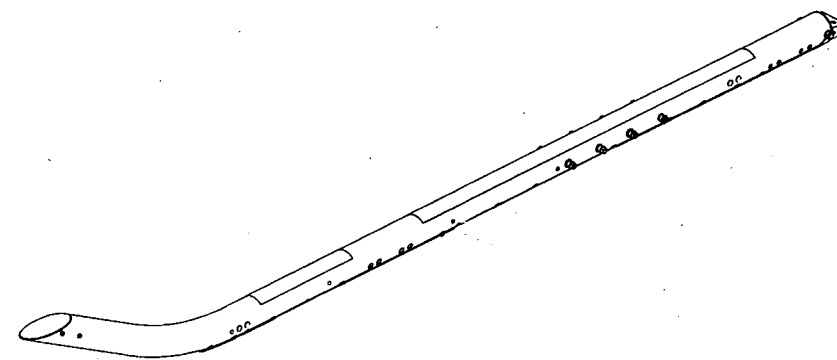
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08-07-16

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CHECKED	SA	DRAWING NO.	REV. F
MFG. APPR.	MA	D2750	SHEET 2 OF 11
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DE APPR.	MA	350 SKIDTUBE ASSEMBLY	NTS
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D2750-043 350 SKIDTUBE ASSEMBLY, LH

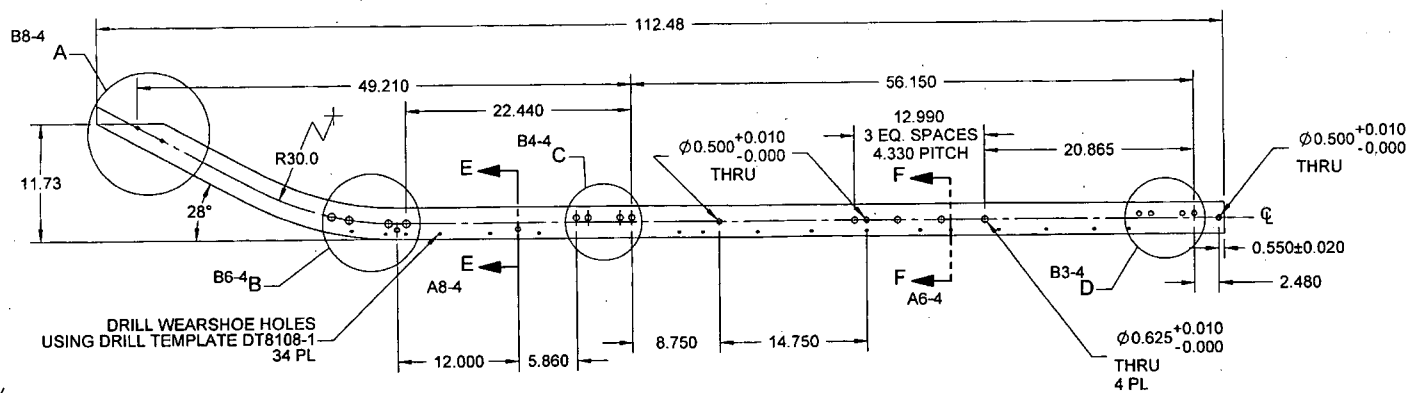


D2750-044 350 SKIDTUBE ASSEMBLY, RH

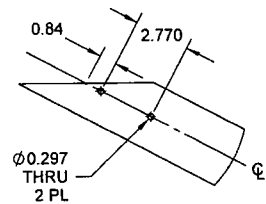
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CHECKED	PH	DRAWING NO. D2750	REV. F
MFG. APPR.	PH	SHEET 3 OF 11	
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	350 SKIDTUBE ASSEMBLY	
DATE	08.07.16	NTS	
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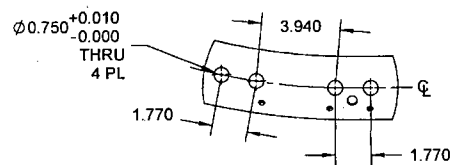
W/O 31902



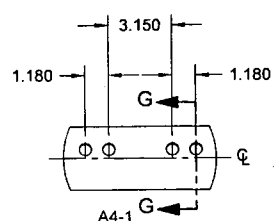
D2750-1 LH SKIDTUBE



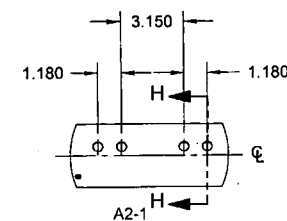
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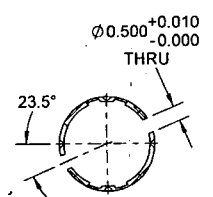
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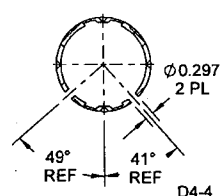
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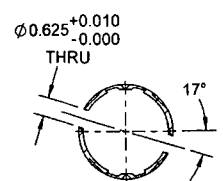
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SCALE 2X



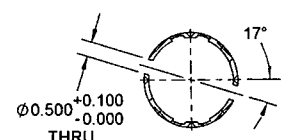
SECTION E-E
SCALE 3X, 2 PL



SECTION F-F
SCALE 3X, 17 PL



SECTION G-G
SCALE 3X, 4 PL

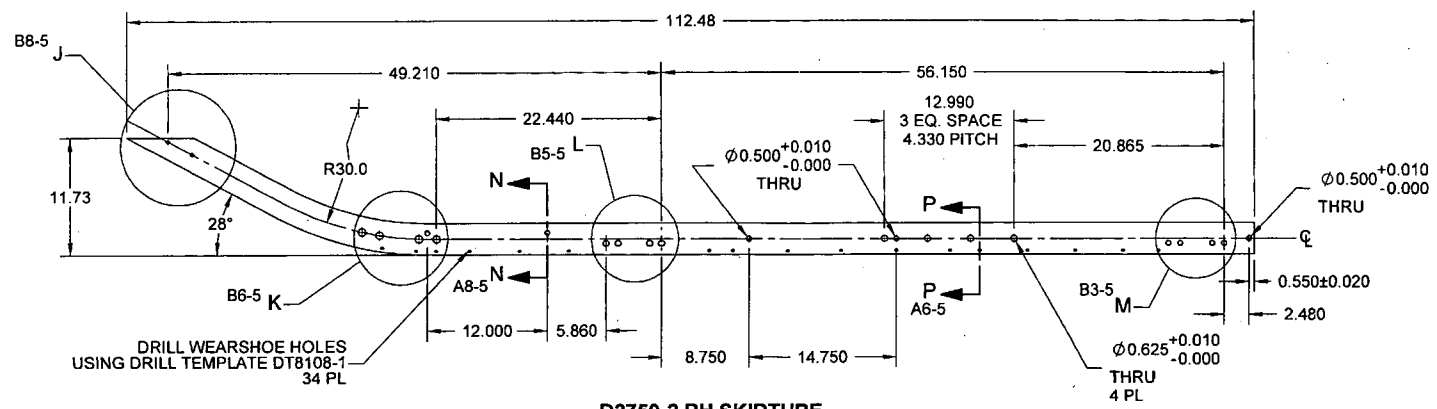


SECTION H-H
SCALE 3X, 4 PL

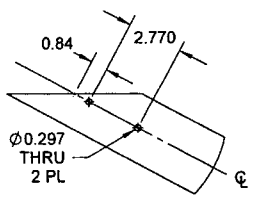
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CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2750	SHEET 4 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	<small>COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

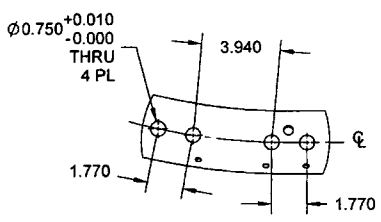
W/O 51902



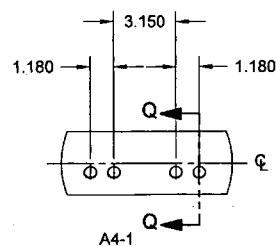
D2750-2 RH SKIDTUBE



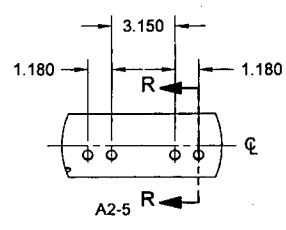
DETAIL J
SCALE 2X



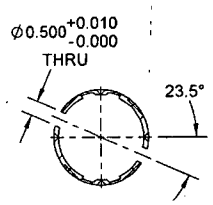
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SCALE 2X



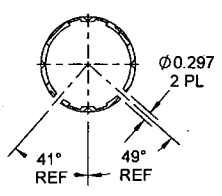
DETAIL L
SCALE 2X



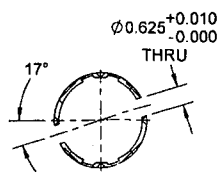
DETAIL M
SCALE 2X



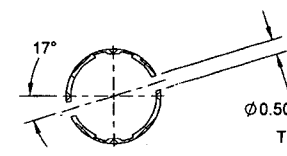
SECTION N-N
SCALE 3X, 2 PL



SECTION P-P
SCALE 3X, 17 PL



SECTION Q-Q
SCALE 3X, 4 PL

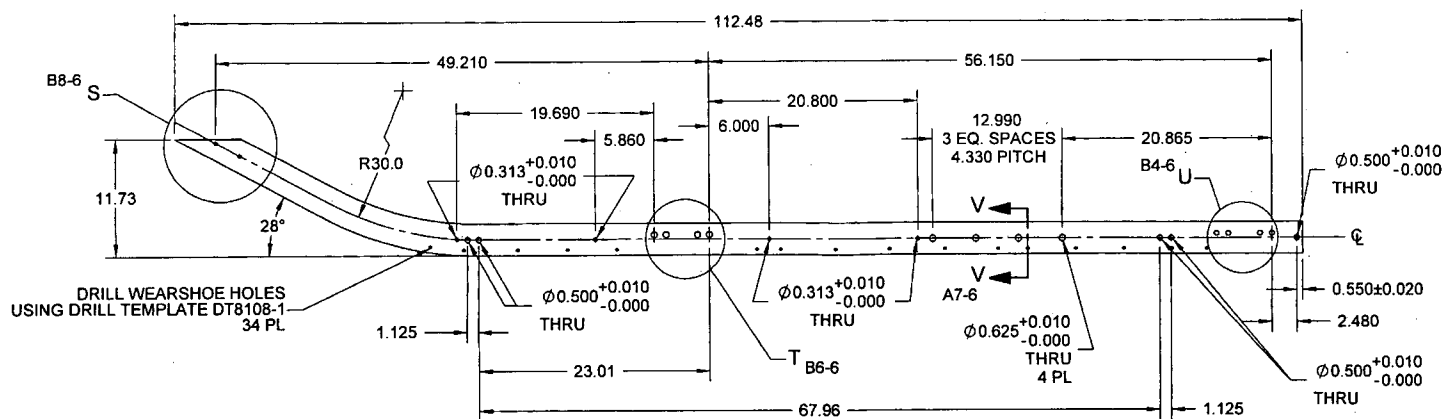


SECTION R-R
SCALE 3X, 4 PL

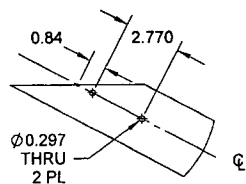
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MFG. APPR.		D2750	SHEET 5 OF 11
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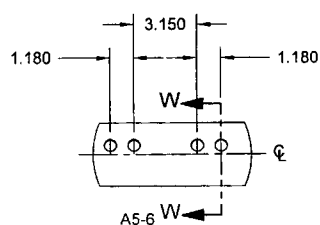
W/O 51902



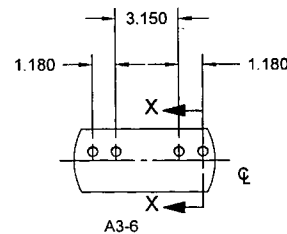
D2750-3 LH SKIDTUBE



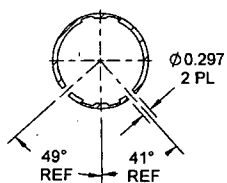
DETAIL S
SCALE 2X



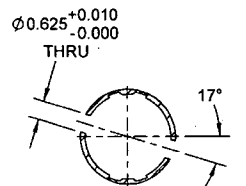
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SCALE 2X



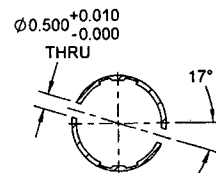
DETAIL U
SCALE 2X



SECTION V-V
SCALE 3X, 17 PL



SECTION W-W
SCALE 3X, 4 PL

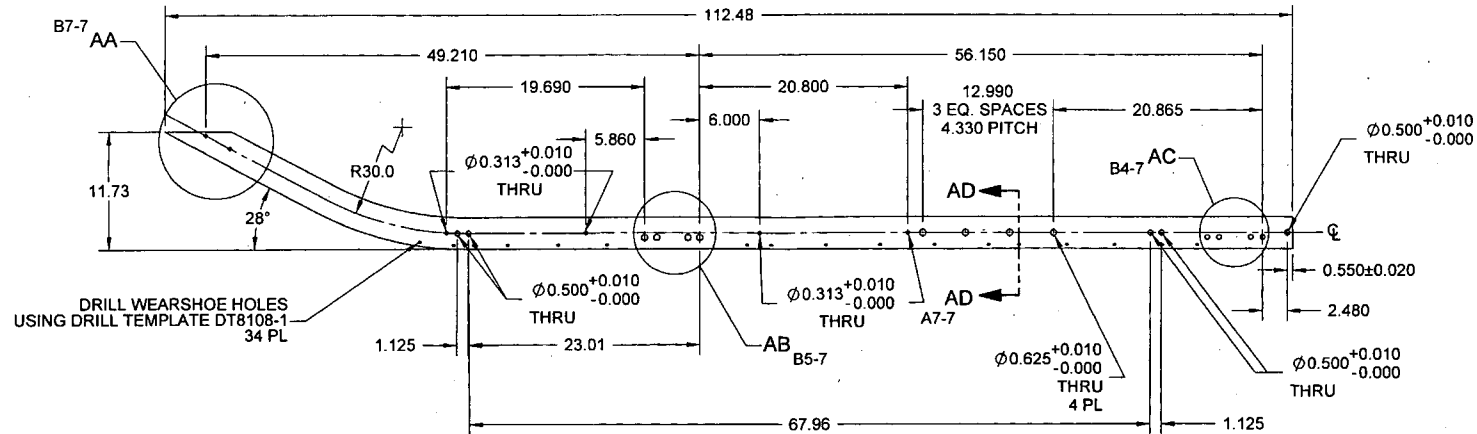


SECTION X-X
SCALE 3X, 4 PL

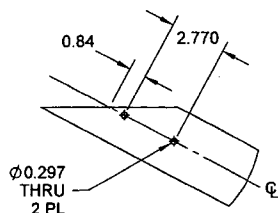
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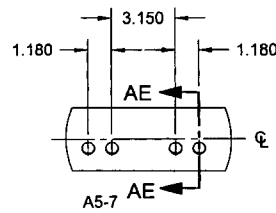
4/0 51902



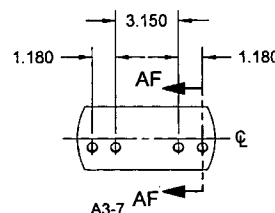
D2750-4 RH SKIDTUBE



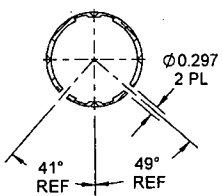
DETAIL AA
SCALE 2X



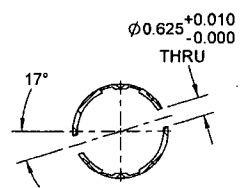
DETAIL AB
SCALE 2X



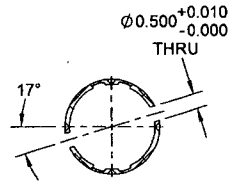
DETAIL AC
SCALE 2X



SECTION AD-AD
SCALE 3X, 17 PL



SECTION AE-AE
SCALE 3X, 4 PL

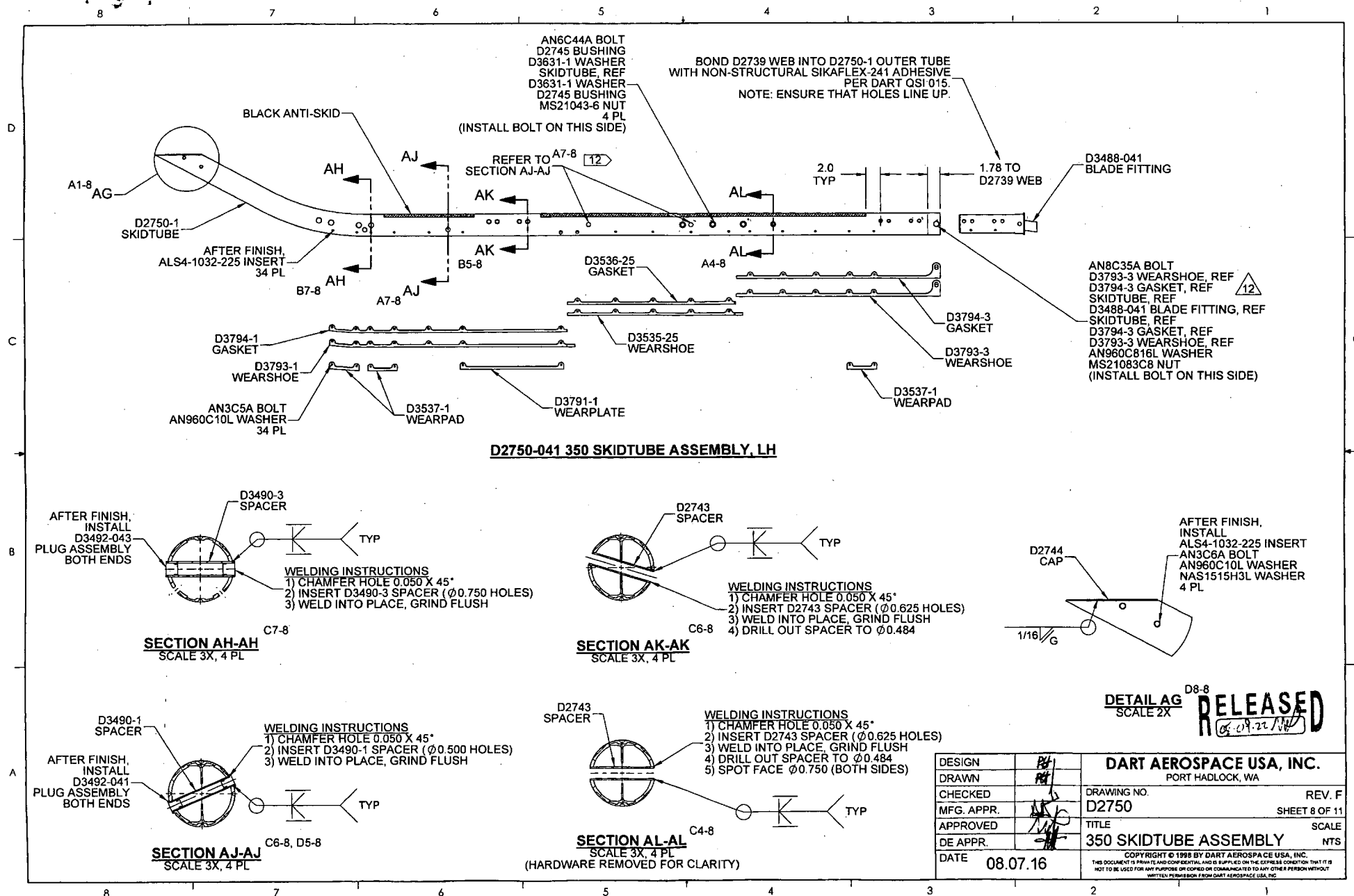


SECTION AF-AF
SCALE 3X, 4 PL

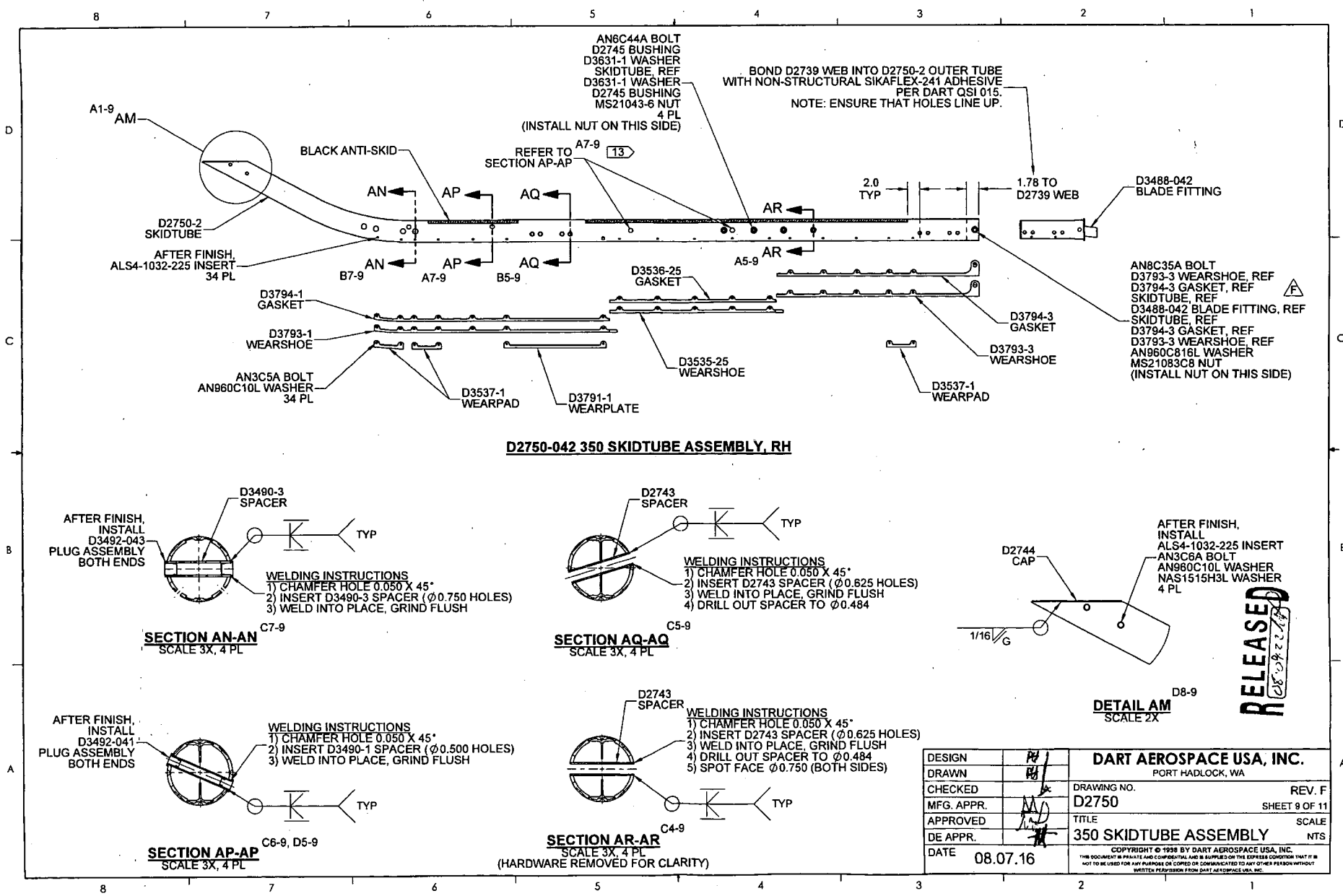
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A1-10 AS
 BLACK ANTI-SKID
 REFER TO SECTION AW-AW
 A4-10
 AN8C44A BOLT
 D2745 BUSHING
 D3631-1 WASHER
 SKIDTUBE, REF
 D3631-1 WASHER
 D2745 BUSHING
 MS21043-6 NUT
 4 PL
 (INSTALL BOLT ON THIS SIDE)
 D2750-3 SKIDTUBE
 AFTER FINISH
 ALS4-1032-225 INSERT
 34 PL
 REFER TO SECTION AU-AU
 A7-10
 B7-10
 D3794-1 GASKET
 D3793-1 WEARSHOE
 AN3C5A BOLT
 AN960C10L WASHER
 34 PL
 D3537-1 WEARPAD
 D3791-1 WEARPLATE
 D3536-25 GASKET
 D3535-25 WEARSHOE
 A7-10
 B4-10
 A4-10
 D3794-3 GASKET
 D3793-3 WEARSHOE
 D3537-1 WEARPAD
 D3488-041 BLADE FITTING
 1.78 TO D2739 WEB
 2.0 TYP
 BOND D2739 WEB INTO D2750-3 OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015.
 NOTE: ENSURE THAT HOLES LINE UP.
 AN8C35A BOLT
 D3793-3 WEARSHOE, REF
 D3794-3 GASKET, REF
 SKIDTUBE, REF
 D3488-041 BLADE FITTING, REF
 SKIDTUBE, REF
 D3794-3 GASKET, REF
 D3793-3 WEARSHOE, REF
 AN960C816L WASHER
 MS21083C8 NUT
 (INSTALL BOLT ON THIS SIDE)

D2743 SPACER

Ø 0.625

WELDING INSTRUCTIONS

- 1) CHAMFER HOLE 0.050 X 45°
- 2) INSERT D2743 SPACER (Ø 0.625 HOLES)
- 3) WELD INTO PLACE, GRIND FLUSH
- 4) DRILL OUT SPACER TO Ø 0.484

WELDING INSTRUCTIONS

- 1) CHAMFER HOLE $0.050 \times 45^\circ$
- 2) INSERT D2743 SPACER ($\phi 0.625$ HOLES)
- 3) WELD INTO PLACE, GRIND FLUSH
- 4) DRILL OUT SPACER TO $\phi 0.484$
- 5) SPOT FACE $\phi 0.750$ (BOTH SIDES)

Diagram illustrating the D3492-045 Plug Assembly. The assembly consists of a circular plug with a central hole. The plug is labeled "D3492-045 PLUG ASSEMBLY BOTH ENDS". A "D3490-5 SPACER" is shown inserted into the central hole. The diagram includes the following text:

AFTER FINISH, INSTALL D3492-045 PLUG ASSEMBLY BOTH ENDS

D3490-5 SPACER

WELDING INSTRUCTIONS

- 1) CHAMFER HOLE 0.050 X 45°
- 2) INSERT D3490-5 SPACER ($\phi 0.313$ HOLES)
- 3) WELD INTO PLACE, GRIND FLUSH

The diagram also shows a cross-section view of the plug and spacer, with a "TYP" label indicating a typical view.

AFTER FINISH,
INSTALL
D3492-041
PLUG ASSEMBLY
BOTH ENDS

D3490-1
SPACER

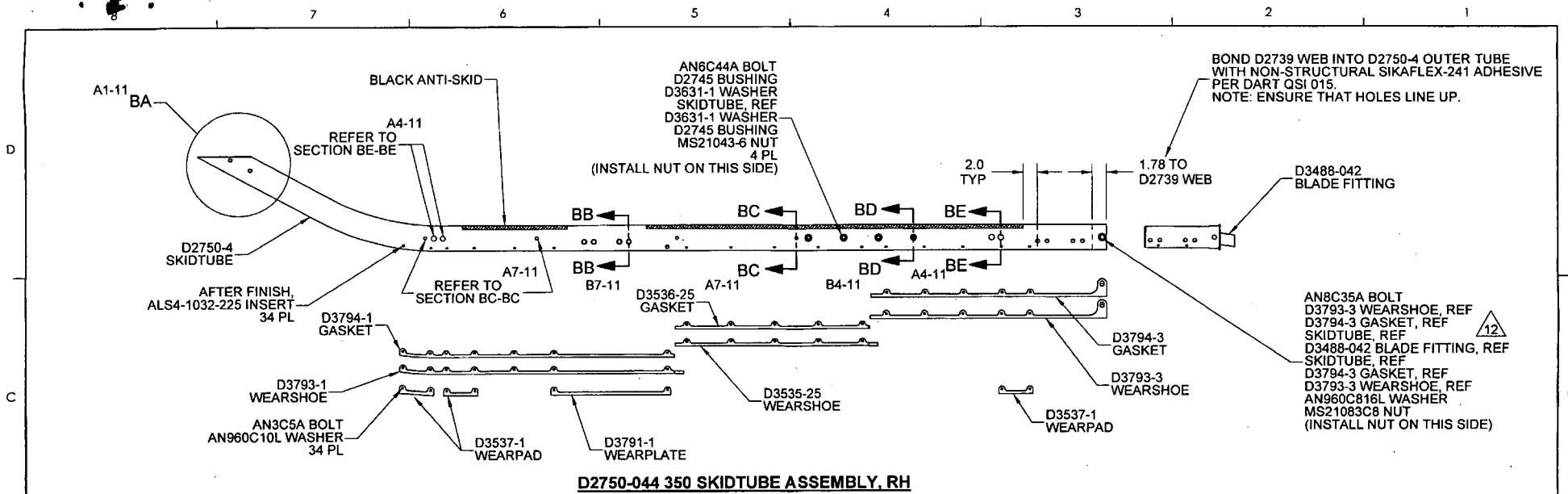
WELDING INSTRUCTIONS
1) CHAMFER HOLE 0.050 X 45°
2) INSERT D3490-1 SPACER (Ø 0.500 HOLES)
3) WELD INTO PLACE, GRIND FLUSH

DESIGN
DRAWN
CHECKED
MFG. APPR.

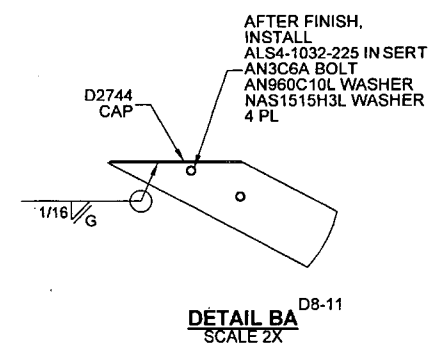
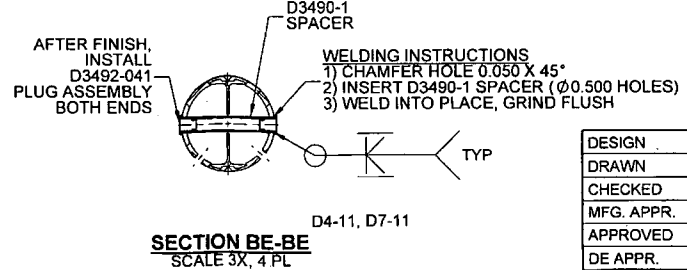
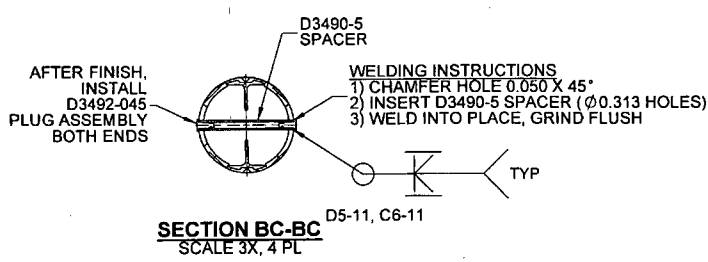
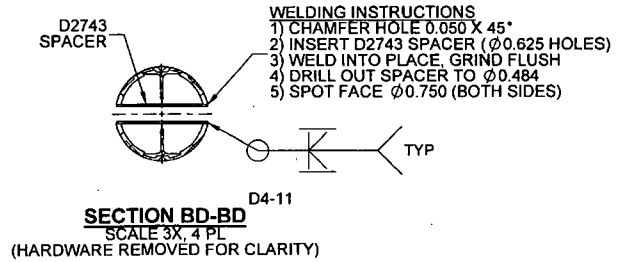
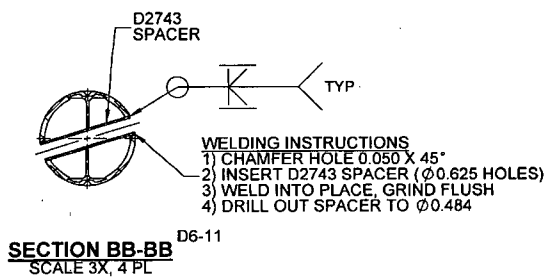
TYP

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MFG APPR.	<i>AS</i>	D2750	SHEET 10 OF 11
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D2750-044 350 SKIDTUBE ASSEMBLY, RH



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NO. 209

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: A. R. Avel
Job number: 51803
Part number: A350-636-011
Description: 350 Skid tube
Welding Process: Tig[☒] Mig[]
Base material: Alum
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier David Avel Date of Test Coupon 09/09/28
Welder A. R. Avel Date of Test Coupon 09.09.28

The above named individual is qualified in accordance with AWS D17.1.2001 to weld